

Date: Wednesday, 11/07/2007 8:41:25 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 33333  
 Estimate Number : 10750  
 P.O. Number :  
 This Issue : 11/07/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 33333  
 Written By : W  
 Checked & Approved By : W  
 Comment : Est: A 05.05.12 New issue KJ/JLM  
 Est Rev:B As per Rev B 06-03-24 JLM  
 Est Rev:C Now on Waterjet 07-07-11 JLM

Drawing Name : WEARPLATE  
 Part Number : D33156  
 Drawing Number : D3315 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 31/07/2007 Qty: 6 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 1.9262 sf(s)/Unit Total: 11.5574 sf(s)  
 1010/1025/A21/6aA SHEET .060" THK  
 BATCH: M104 948

SAD 07/07/24 "Scrap" ①  
 SAD 07/07/24 ⑥

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3315  
 Dwg Rev: B  
 Prog Rev: B

2-Deburr if necessary

SAD 07/07/24 6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/24 6

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/07/24 ⑥

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SAD 07/12/10 ⑥

Date: Wednesday, 11/07/2007 8:41:25 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33333

Part Number: D33156

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK



5 07/12/10 x6 (6x) (C)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: D

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

Batch m106390

FC 08/01/10 (6x) (C)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



08-01-10 (6x) (C)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442



M-L 08/01/18 (6x) (C)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT



BR 08-01-18 (6x) (C) PTD

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: ST 495

AS 08/01/18 (6x) (C)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08-01-21

Job Completion



08-01-21

Date: Monday, 7/9/2007 11:42:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 33333	
Estimate Number : 10750	
P.O. Number :	Part Number : D33156
This Issue : 7/9/2007 S.O. No. :	Drawing Number : D3315 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 26188	Material :
Written By :	Due Date : 7/30/2007 Qty: 6 Um: Each
Checked & Approved By : <u>7/10/07.09</u>	
Comment : Est: A 05.05.12 New issue KJ/JLM	
Est Rev:B As per Rev B 06-03-24 JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3315

Possible Supplier: Industrial Laser

Material release note is required

*Handwritten notes:*  
 11/01/05/16/07  
 1-83155  
 W. H. H. H. H.

2.0

D33156F

Wearplate Flat Pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 WEARPLATE

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3315-6T2

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3315-6 PAR #: N/A Fault Category: Plan - Sm. FAB. NCR: Yes No DQA: X Date: 08.01.24  
 (WS) QA: N/C Closed: X Date: 08.01.22

NCR: <u>33333</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/24	2.0	One part scrap Dxf error and offset had to change hole were to big	<u>[Signature]</u>	Scrap & destroy replace Fix Dxf error	<u>SAB</u> 07/07/24 <u>[Signature]</u> 07.02.24	<u>[Signature]</u> 07.02.24	<u>[Signature]</u> 07.02.24	<u>[Signature]</u> 07.02.24

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:42:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33333

Part Number: D33156

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: \_\_\_\_\_

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: \_\_\_\_\_

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 7/9/2007 11:42:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33333

Part Number: D33156

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

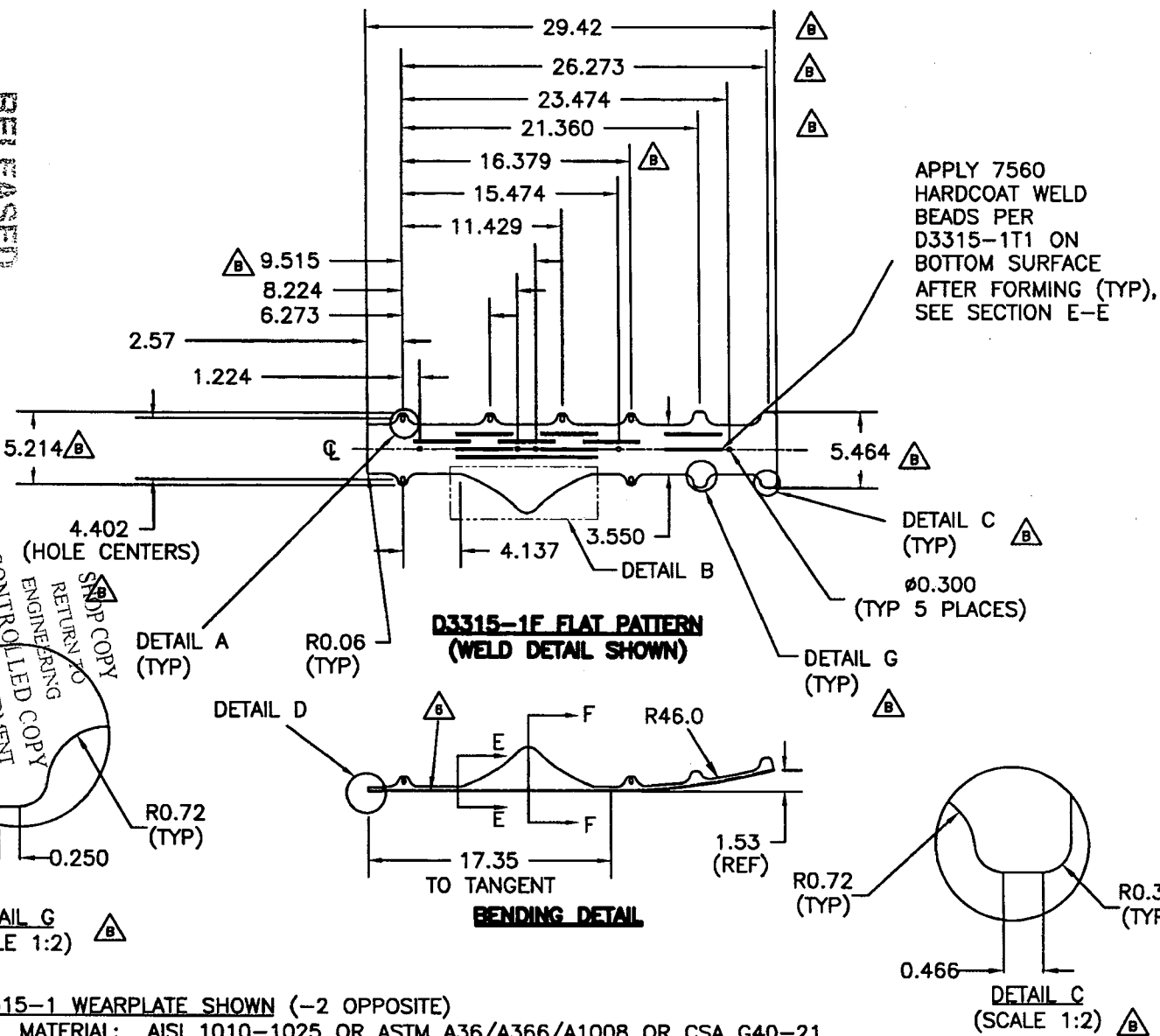
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 1 OF 4
				SCALE
				1:12
A	04.09.10	NEW ISSUE		
B	06.01.31	UPDATE DIMENSIONS		

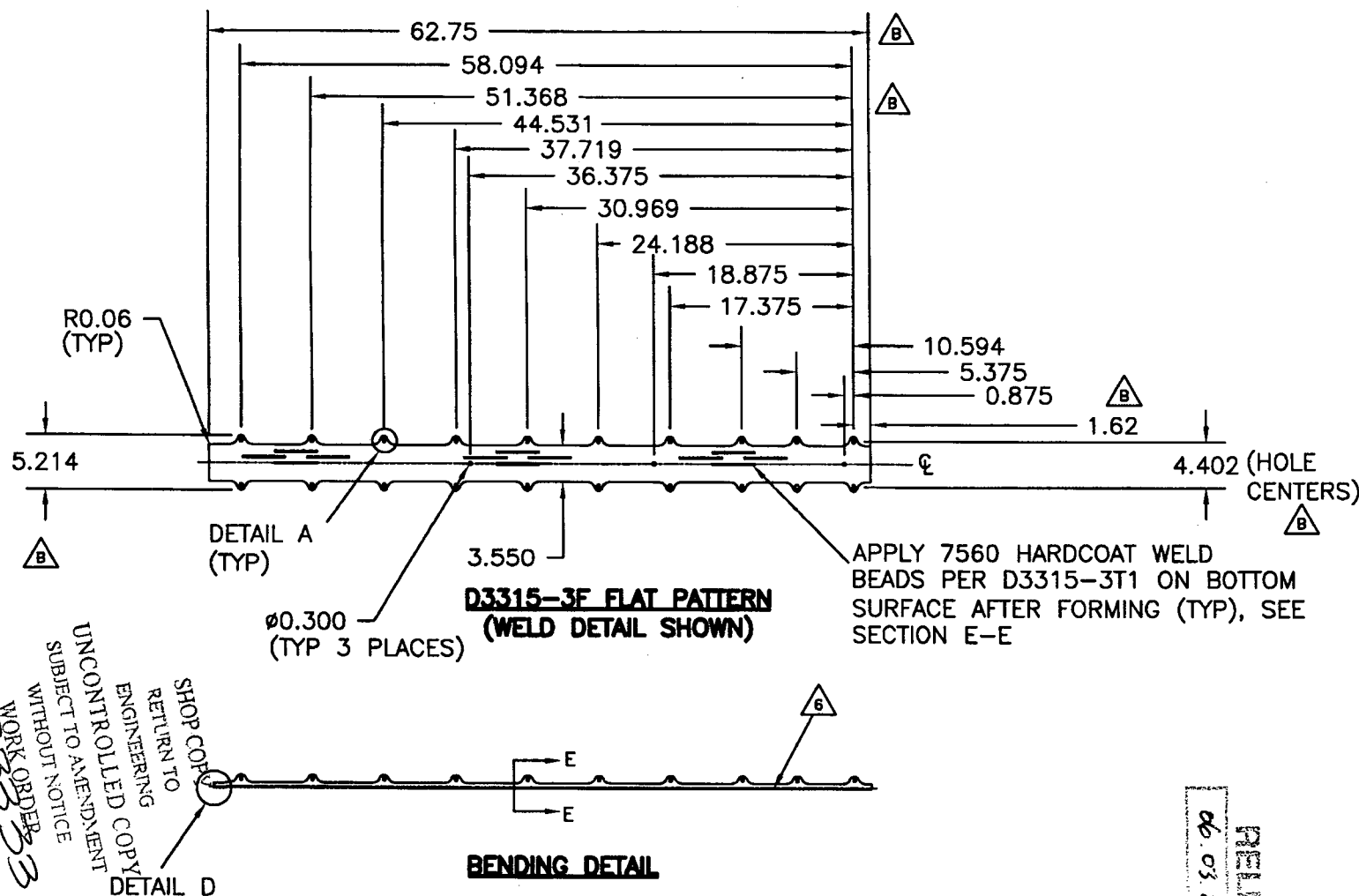


- D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- \*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
06.03.20 *[Signature]*

**DART**

DESIGN	PH	DRAWN BY	PH	<b>DART AEROSPACE LTD</b>
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 4
		SCALE	1:18	

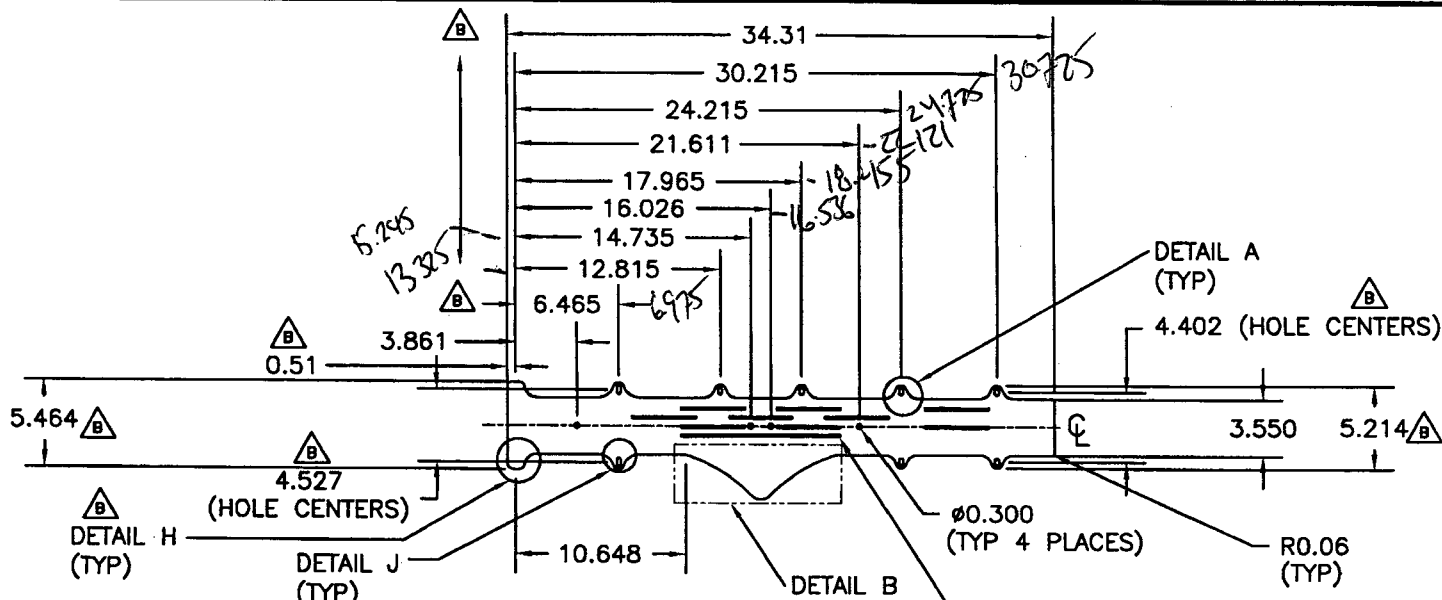


**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

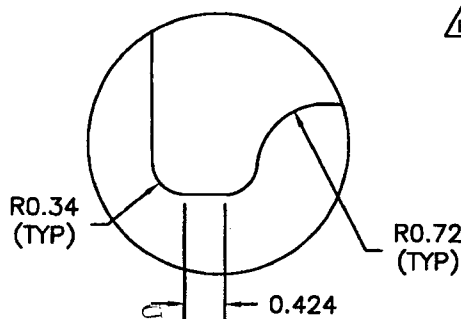
**DART**

DESIGN	GH	DRAWN BY	GH	<b>DART AEROSPACE LTD</b>
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3315	SHEET 3 OF 4
		SCALE	1:12	

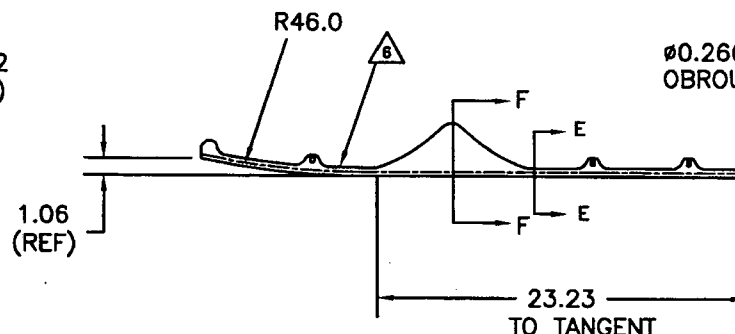


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

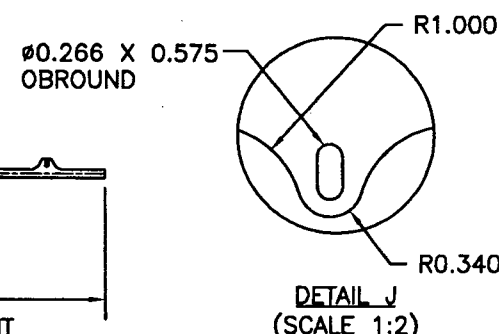
APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



DETAIL H  
(SCALE 1:2)  
TOP COPY  
RETURN TO  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

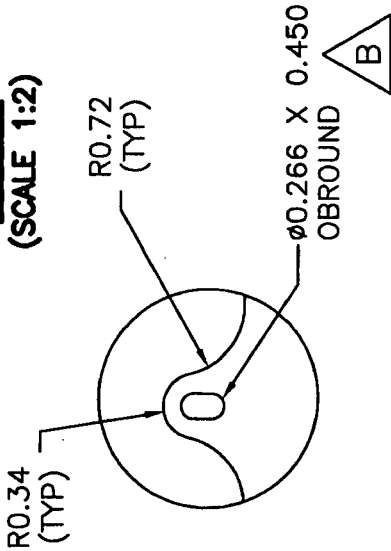
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

06 03 20  
RELEASED

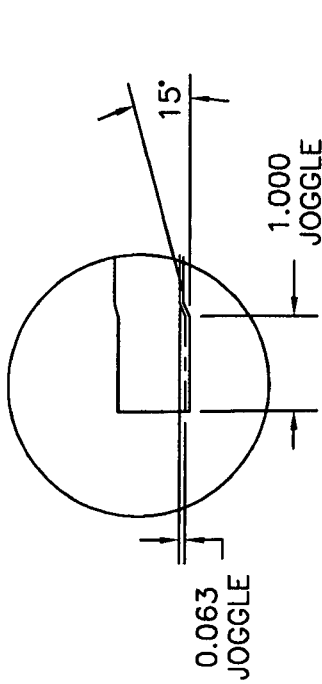


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

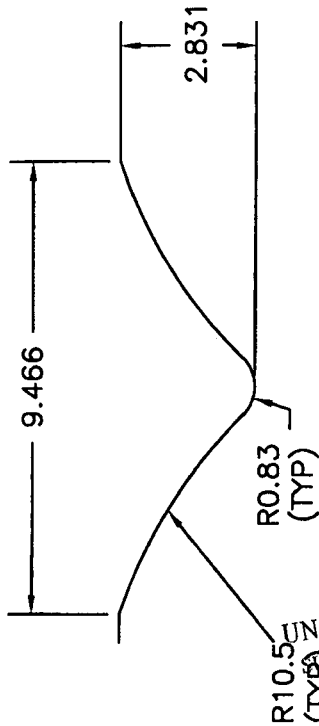
**DETAIL A**  
(SCALE 1:2)



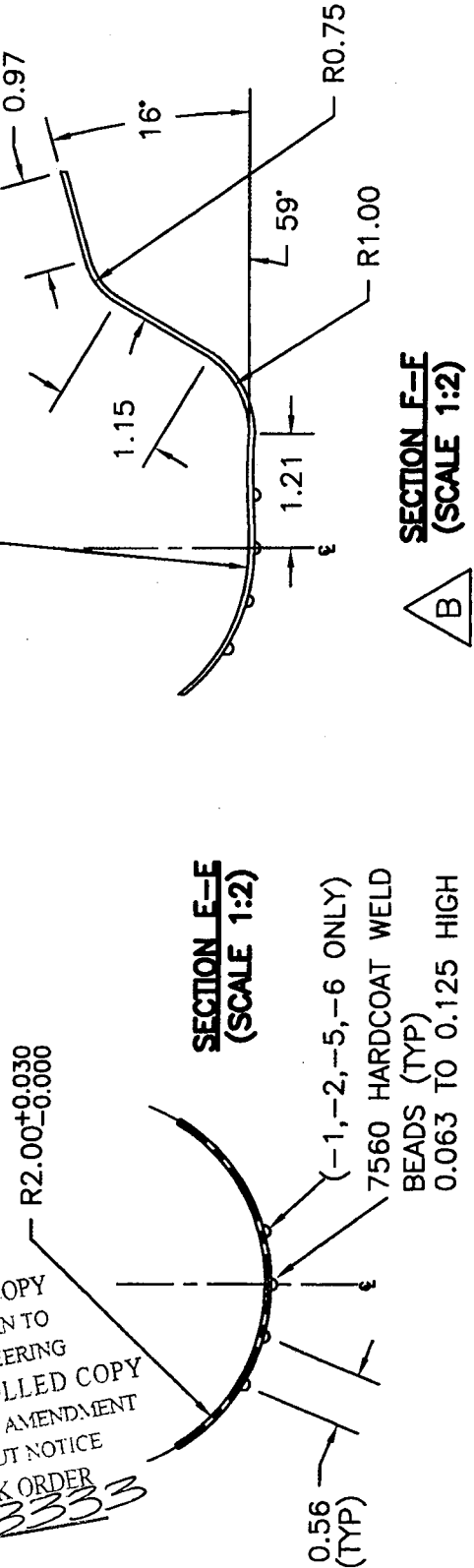
**DETAIL D**  
(SCALE 1:2)



**DETAIL B**  
(SCALE 1:4)



**SECTION E-E**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33333

RELEASED  
06.03.20

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DART AEROSPACE LTD		Work Order:	33333
Description: WEARPLATE		Part Number:	D33156
Inspection Dwg: D3315 Rev: 8		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	✓		M-T	
30.215	+/-0.010	30.215	✓		M-T	
24.215	+/-0.010	24.215	✓		M-T	
21.611	+/-0.010	21.611	✓		M-T	
17.965	+/-0.010	17.970	✓		M-T	
16.026	+/-0.010	16.026	✓		M-T	
14.735	+/-0.010	14.735	✓		M-T	
12.815	+/-0.010	12.815	✓		M-T	
6.465	+/-0.010	6.470	✓		M-T	
5.464	+/-0.010	5.465	✓		Vern	
4.527	+/-0.010	4.531	✓		Vern	
3.550	+/-0.010	3.555	✓		Vern	
5.214	+/-0.010	5.215	✓		Vern	
Ø 0.300	+0.006/-0.001	Ø 0.304	✓		Vern	
Ø 0.266 X 0.575	+/-0.010	Ø 0.273 X 0.572	✓		Vern	
Ø 0.266 X 0.450	+/-0.010	Ø 0.272 X 0.452	✓		Vern	

Measured by: <u>SXP</u>	Audited by: <u>En</u>	Prototype Approval: <u>M/A</u>
Date: <u>07/07/24</u>	Date: <u>07/07/24</u>	Date: <u>M/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

